



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7335

Job Sheet 212371



Part No: 647.7335

Job Qty: 1 pcs

Part Name: EC135 T2/P2 Lower Cutter Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/21/20

Job Tracking No:

Due Date: 10/26/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.7300 REV.F IPP REV:A 2020.04.01 NEW ISSUE DD VERF:RQ IPP REV:B 2020.06.19 ASPER
DWG REV.F DD VERF:RQ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		10/26/20	0.00	0.00	Packaging 1 - 1		80
							Packaging 1 - 2		80
							Packaging 1 - 3		80
							Packaging 1 - 4		9-89
							Packaging 1 - 5		
							Packaging 1 - 6		DAS
							Packaging 1 - 7		28
							Packaging 1 - 8		9-89
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Container No: S306736



Part: 647.7335

Job No: 212371

Serial No/Batch: S306736

Revision: REV.G

Inspector:

Exp Date:

Instructions:

Date: 10/16/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 8/21/20 9:04 AM Dart.lajeunesse.marie

					Packaging 1 - 31						
					Packaging 1 - 32						
					Packaging 1 - 33						
					Packaging 1 - 34						
					Packaging 1 - 35						
					Packaging 1 - 36						
					Packaging 1 - 37						
					120 QC 4	1 pcs	10/26/20	0.00 0.00		QC 4 - 28	
QC 4 - 58											
QC 4 - 69	DAS										
QC 4 - 9	69										
QC 4 - 46	9-89										
QC 4 - 68											
QC 4 - 72											
QC 4 - 74											
QC 4 - 75											
QC 4 - 78											
QC 4 - 84											
QC 4 - 80											
QC 4 - 85											
130 Packaging 3-1 - Stock - B4B	1 pcs	10/26/20	0.00 0.00							Packaging 3 - 1 - B4B	
										Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B						
					Packaging 3 - 4 - B4B						
					Packaging 3 - 5 - B4B						
					Packaging 3 - 6 - B4B						
					Packaging 3 - 7 - B4B						
					Packaging 3 - 8 - B4B						
					Packaging 3 - 9 - B4B	DAS					
					Packaging 3 - 10 - B4B	69					
					Packaging 3 - 11 - B4B	9-89					
					Packaging 3 - 12 - B4B						
					Packaging 3 - 13 - B4B						
					Packaging 3 - 14 - B4B						
					Packaging 3 - 15 - B4B						
					Packaging 3 - 16 - B4B						
					Packaging 3 - 17 - B4B						
					Packaging 3 - 18 - B4B						
					Packaging 3 - 19 - B4B						
					Packaging 3 - 20 - B4B						
					Packaging 3 - 21 - B4B						
					Packaging 3 - 22 - B4B						
					Packaging 3 - 23 - B4B						
					Packaging 3 - 24 - B4B						
					Packaging 3 - 25 - B4B						
					Packaging 3 - 26 - B4B						
					Packaging 3 - 27 - B4B						
					Packaging 3 - 28 - B4B						
					Packaging 3 - 29 - B4B						
					Packaging 3 - 30 - B4B						
					Packaging 3 - 31 - B4B						
					Packaging 3 - 32 - B4B						
					Packaging 3 - 33 - B4B						
					Packaging 3 - 34 - B4B						
					Packaging 3 - 35 - B4B						
					Packaging 3 - 36 - B4B						
					Packaging 3 - 37 - B4B						
135 DC - 1 - B4B	1 pcs	10/26/20	0.00 0.00		DC - 1 - B4B						
					DC - 2 - B4B	0707 61 100					
					Plex 8/21/20 9:04 AM Dart.lajeunesse.marie						

140 QC 21 - FG	1 pcs	10/26/20	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 9	OCT 19 2020
				QC 21 - FG - 77	DAS 70 9-89

Part Op 110 - (Pick Kit)
 Descriptions: 120 - (QC4- 100% Inspect kits for completeness)
 130 - Identify and pack for shipping as per PPP 647.7335
 135 - (Document Control) Photocopy bluefile & type labels per PPP 647.7335
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
601.3902	Eye Bolt	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L5	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0532P	Washer (AN960-516L)	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	see attached
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	msl
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
647.7501	Lower Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
647.7702	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	
93635A212	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	DAS 70 9-89
AN3-11A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L3	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	
NAS1149C0432R	Washer (AN960C416L)	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	
NAS1149F0332P	Washer (AN960-10L)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	
NAS1149FN832P	Washer (AN960-8)	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0990	1	9	0
	600.0991	1	10	0
	600.1012	1	22	0
	601.2045	1	14	0
	601.3902	2	38	0
	647.0112	2	76	0
	647.7501	1	16	0
	647.7702	2	30	0
	93635A212	4	57	0
	AN3-11A	2	131	0
	AN316C4R	2	65	0
	AN44-5A	2	13	0
	AN4C7A	2	146	0
	AN665-34R	2	52	0
	MS21042L08	2	790	0
	MS21042L3	2	1,178	0
	MS21042L4	2	1,911	0
	MS21042L5	2	356	0
	MS27039-08-13	2	93	0
	NAS1149C0432R	8	1,438	0
	NAS1149F0332P	4	1,665	0
	NAS1149F0532P	2	1,407	0
	NAS1149FN832P	4	1,239	0

Part Specifications

Specifications could not be found.

Plex 8/21/20 9:04 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Job Fabrication

Job No: 212371

Part No: 647.7335

Sort by: ☐ Location ☒ Component

Operation	Required	Component	Description	BOM Quantity	Quantity Required	Quantity Available	Location	Container No	Serial No/Batch	Quantity Picked
110-Packaging 1 - Pick Kit	1	600.0990 ✓ <i>Exp Date 10/07/2021</i>	Magnabond 6398 Part A Size 112 ml	1.0000	1.0000	1.0000	LG049	S301938	S301938	0
						18.0000	LG049	S306325	S306325	1
110-Packaging 1 - Pick Kit	1	600.0991 ✓ <i>Exp Date 10/07/2021</i>	Magnabond 6398 Part B Size 112 ml	1.0000	1.0000	1.0000	LG049	S301939	S301939	0
						18.0000	LG049	S306327	S306327	1
110-Packaging 1 - Pick Kit	1	600.1012 ✓ <i>Exp Date 02/01/2021</i>	Sealant PR1425B2 (#654 sem)	1.0000	1.0000	14.0000	CCK017	S297581	S297581	1
						1.0000	CCK017	S301302	S301302	0
						25.0000	CCK017	S304849	S304849	0
110-Packaging 1 - Pick Kit	1	601.2045 ✓ <i>Exp Date 12/10/2021</i>	RTV (LOCTITE 598)	1.0000	1.0000	11.0000	CCK095C	S299615	S299615	1
						7.0000	CCK095C	S301820	S301820	0
						37.0000	CCK095C	S304317	S304317	0
110-Packaging 1 - Pick Kit	1	601.3902 ✓	Eye Bolt	2.0000	2.0000	1.0000	CCK100	S114848	S114848	0
						25.0000	CCK100	S248574	S248574	0
						4.0000	CCK100	S287010	S287010	2
110-Packaging 1 - Pick Kit	1	647.0112 ✓	Strut Bracket	2.0000	2.0000	18.0000	CCK106	S258631	S258631	2
110-Packaging 1 - Pick Kit	1	647.7501 ✓	Lower Cutter Assembly	1.0000	1.0000	2.0000	CCK042	S262104	S262104	0
						6.0000	CCK042	S267991	S267991	1
						1.0000	CCK042	S287320	S287320	0
						3.0000	CCK042	S287339	S287339	0
110-Packaging 1 - Pick Kit	1	647.7702 ✓	Strut Assembly	2.0000	2.0000	8.0000	CCK076	S243383	S243383	0
						14.0000	CCK076	S258859	S258859	2
110-Packaging 1 - Pick Kit	1	93635A212 ✓	Bolt	4.0000	4.0000	5.0000	ST588	S230428	ST588	0
						15.0000	ST588	S253060	S253060	4
						21.0000	ST588	S255285	S255285	0
110-Packaging 1 - Pick Kit	1	AN3-11A ✓	Bolt	2.0000	2.0000	10.0000	ST349	S228668	S228668	2
						100.0000	ST338F	S301606	S301606	0
						100.0000	ST338F	S304745	S304745	0
110-Packaging 1 - Pick Kit	1	AN316C4R ✓	Nut, Jam	2.0000	2.0000	20.0000	ST325F	S249342	S249342	0
						16.0000	ST331	S289567	S289567	2
110-Packaging 1 - Pick Kit	1	AN44-5A ✓	Eyebolt	2.0000	2.0000	1.0000	ST339	S294746	S294746	1
						14.0000	ST339	S298153	S298153	1

						24.0000	ST339	S304855	S304855	0
110-Packaging 1 - Pick Kit	1	AN4C7A ✓	Bolt	2.0000	2.0000	100.0000	ST338F	S235182	S235182	0
						4.0000	ST345	S251071	S251071	2
110-Packaging 1 - Pick Kit	1	AN665-34R ✓	Clevis	2.0000	2.0000	24.0000	ST330	S235821	S235821	0
						20.0000	ST330	S304774	S304774	2
110-Packaging 1 - Pick Kit	1	MS21042L08 ✓	Nut	2.0000	2.0000	4.0000	ST303	S283266	S283266	0
						300.0000	ST299F	S287749	S287749	0
						100.0000	ST299F	S294914	S294914	0
						46.0000	ST303	S304833	S304833	2
110-Packaging 1 - Pick Kit	1	MS21042L3 ✓	Nut	2.0000	2.0000	300.0000	ST299F	S285188	S285188	0
						5.0000	ST303	S294915	S294915	0
						198.0000	ST299F	S299966	S299966	0
						6.0000	ST303	S299967	S299967	2
						392.0000	FP001	S304836	S304836	0
						8.0000	ST303	S305597	S241744	0
110-Packaging 1 - Pick Kit	1	MS21042L4 ✓	Nut	2.0000	2.0000	2.0000	ST303	S305673	S204283	0
						11.0000	GA011	S228833	S228833	0
						78.0000	FP001	S278891	S278891	0
						920.0000	ST299F	S282343	S282343	0
						145.0000	ST303	S298133	S298133	2
110-Packaging 1 - Pick Kit	1	MS21042L5 ✓	Nut	2.0000	2.0000	892.0000	ST303	S304876	S304876	0
						77.0000	FP001	S283904	S283904	0
						1.0000	ST303	S293756	S293756	1
110-Packaging 1 - Pick Kit	1	MS27039-08-13 ✓	Screw	2.0000	2.0000	100.0000	ST303	S302482	S302482	1
						35.0000	ST278	S123937	S123937	2
110-Packaging 1 - Pick Kit	1	NAS1149C0432R	Washer (AN960C416L)	8.0000	8.0000	25.0000	ST278	S299991	S299991	0
						398.0000	FP001	S233310	S233310	0
						461.0000	ST266	S256376	S256376	0
						13.0000	ST266	S257777	S257777	8
						16.0000	ST266	S289426	S289426	0
110-Packaging 1 - Pick Kit	1	NAS1149F0332P	Washer (AN960-10L)	4.0000	4.0000	314.0000	ST266	S302173	S302173	0
						7.0000	GA-Alain	S103666-1	S103666	0
						510.0000	FP001	S216387	S216387	0
						0.0000	ST262	S285161	S285161	0
						183.0000	ST262	S297630	S297630	4
						400.0000	ST260A	S302479	S302479	0
110-Packaging 1 - Pick Kit	1	NAS1149F0532P	Washer (AN960-10L)	2.0000	2.0000	800.0000	ST260A	S304834	S304834	0
						600.0000	ST260A	FM133725	M133725	0

10/16/2020

[Dart Hawkesbury] Job Fabrication - Rosales, Oscar

Packaging 1 - Pick Kit			516L)			766.0000	ST262	F18057-4	18057	2
						18.0000	GA200	f18057-4-1	18057	0
110- Packaging 1 - Pick Kit	1	NAS1149FN832P	Washer (AN960-8)	4.0000	4.0000	248.0000	FP001	S136368	S136368	0
						479.0000	ST263	S284016	S284016	4
						200.0000	ST260A	S293710	S293710	0
						600.0000	ST260A	S304796	S304796	0